

Date: Wednesday, 12/5/2007 10:35:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 36142		
Estimate Number	: 11063		
P.O. Number	: <u>N/A</u>	Part Number	: D2935
This Issue	: 12/5/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2935 REV B
Prsht Rev.	: <u>NC</u>	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34174	Material	: <u>N/A</u>
Written By	: <u>AD 07-12-05</u>	Due Date	: 12/24/2007 Qty: 40 Um: Each
Checked & Approved By	: <u>AD 07-12-05</u>		
Comment	: Est A 00-06-06 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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2.66



Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s)

Material: M6061-T6 0.080" Thick

Batch 106320HB 07-12-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2935

Dwg Rev: BProg Rev: BHB 07-12-7

(50)

2-Deburr if necessary

EP 08/01/09 (50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-12-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EP 08/01/09 (50)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-01-12

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 10:35:37 AM
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Drawing Name: SADDLE SPACER

Job Number: 36142

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(50X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. J. 08/01/12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *54*

P. 8/01/12 (50)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

208/01/15

Job Completion



LC 08-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

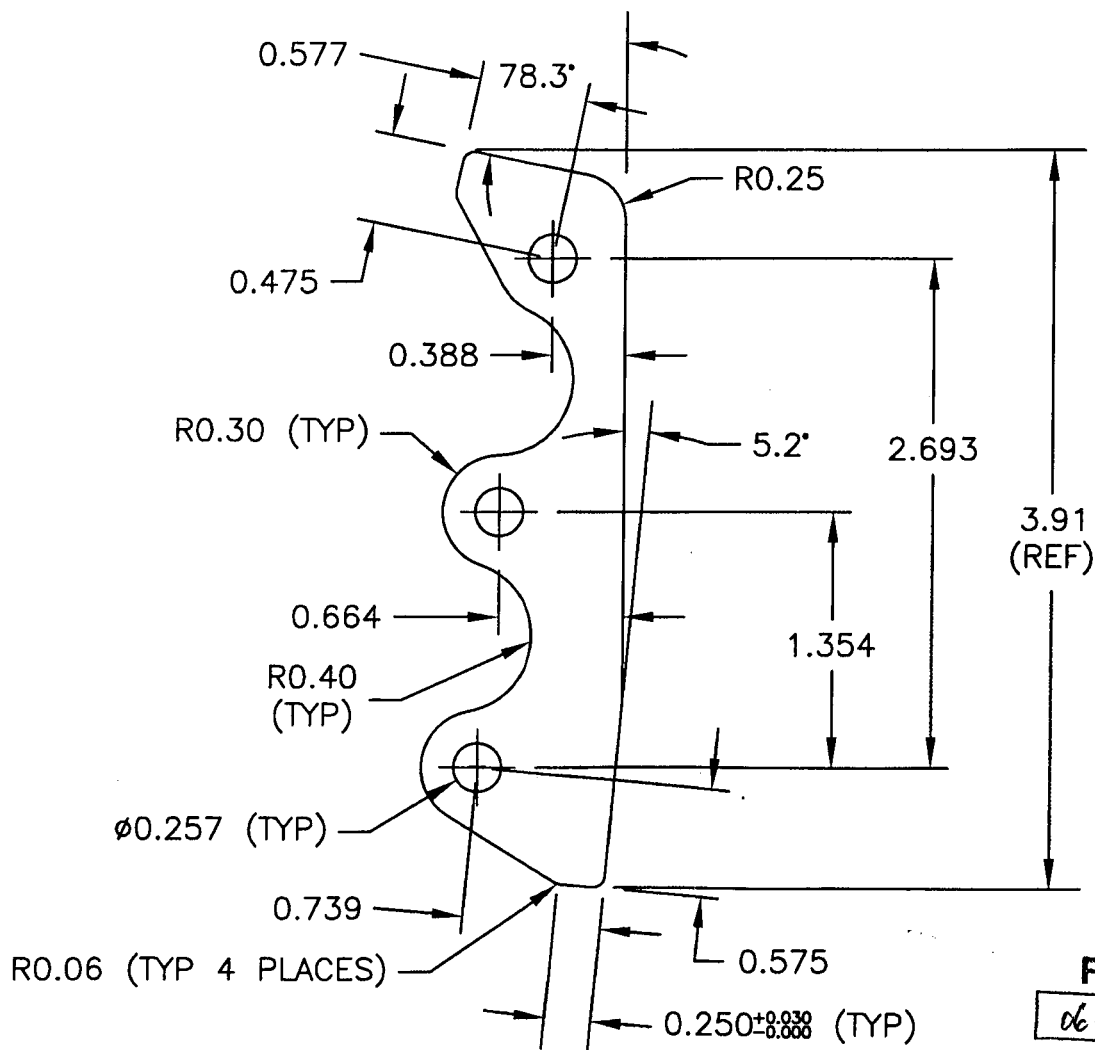
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 7#	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30142

RELEASED

06.06.20 [Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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